

Work Order ID 64310

Thursday, December 02, 2010 8:56:48 AM



Page 1

Item ID: D2151

Accept



Setup Start



Revision ID:

Stop



Item Name: Packer Doubler, Hinge

Start Date: 12/2/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: *10-12-2* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2151	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2151

☐ Dwg Rev: *B*

☐ Prog Rev: *B*

☐ 2-

Deburr if necessary

1310-12-7

(18)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1310-12-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8, 10, 12, 10, 7

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64310

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Page 2

Item ID: D2151	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Packer Doubler, Hinge				
Start Date: 12/2/2010	Start Qty: 10.00		Cust Item ID:	
Required Date: 12/9/2010	Req'd Qty: 10.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Dehurr								
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:55								
	FINISH TIME: 11:25								

=) M 10/12/08

18 0

18 BL 10-12-13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 64310

Thursday, December 02, 2010 8:56:48 AM

Page 3

Item ID: D2151

Accept

Setup Start

Revision ID:

Stop

Item Name: Packer Doubler, Hinge

Start Date: 12/2/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 007

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



= 2.25 10/12/13

18

0

10/12/13 18

CK 10/12/13

mr
10-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 02, 2010 8:56:53 AM

Page 1

Work Order ID: 64310



Parent Item: D2151



Parent Item Name: Packer Dotoler, Hinge

Start Date: 12/2/2010

Required Date: 12/9/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP ☐ C ☐ 00.10.23 ☐ Re-format (mpp 2101) ☐ EC ☐
 IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
 IPP Rev:E 06-11-24 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			110	sf	237.3400	0.035	0.368421			

2024-T3 .040 sheet



B10-12-7

Location

Loc Qty

Loc Code

MAT	47.6
114415	47.6
MAT22	189.74
110305	21.93
111786	9.66
112291	28.25
112331	52
113162	77.9

114415

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	614310
Description: Packer		Part Number:	D2151
Inspection Dwg: D2151 Rev: B		Page 1 of 1	

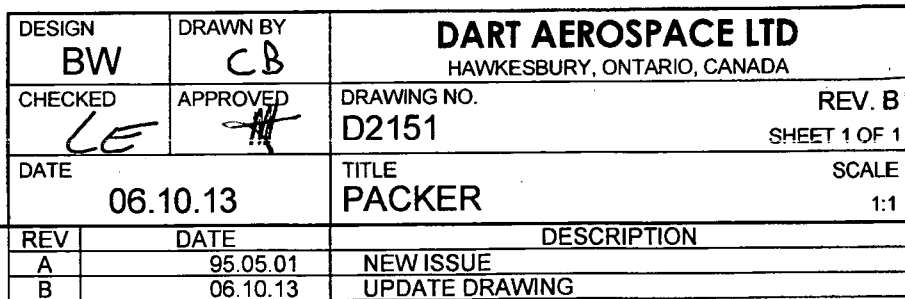
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.090	+0.005/-0.000	.100	<input checked="" type="checkbox"/>		✓ HB02	
Ø0.171	+0.005/-0.000	.172	<input checked="" type="checkbox"/>		✓	
0.231	+/-0.010	.228	<input checked="" type="checkbox"/>		✓	
1.217	+/-0.010	1.217	<input checked="" type="checkbox"/>		✓	
2.194	+/-0.010	2.196	<input checked="" type="checkbox"/>		✓	
2.300	+/-0.010	2.303	<input checked="" type="checkbox"/>		✓	
1.560	+/-0.010	1.560	<input checked="" type="checkbox"/>		✓	
0.250	+/-0.010	.252	<input checked="" type="checkbox"/>		✓	
1.328	+/-0.010	1.329	<input checked="" type="checkbox"/>		✓	
0.342	+/-0.010	.341	<input checked="" type="checkbox"/>		✓	
0.740	+/-0.010	.743	<input checked="" type="checkbox"/>		✓	
2.050	+/-0.010	2.053	<input checked="" type="checkbox"/>		✓	
0.040	+/-0.010	.042	<input checked="" type="checkbox"/>		✓	

Measured by: RB	Audited by: D	Prototype Approval:	N/A
Date: 10-12-7	Date: 10/12/07	Date:	N/A

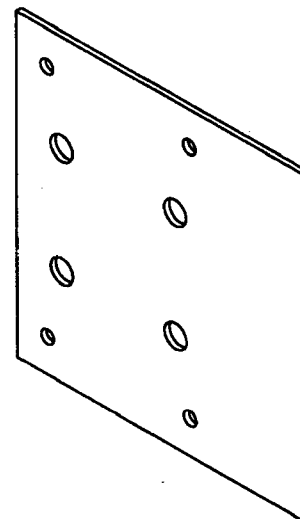
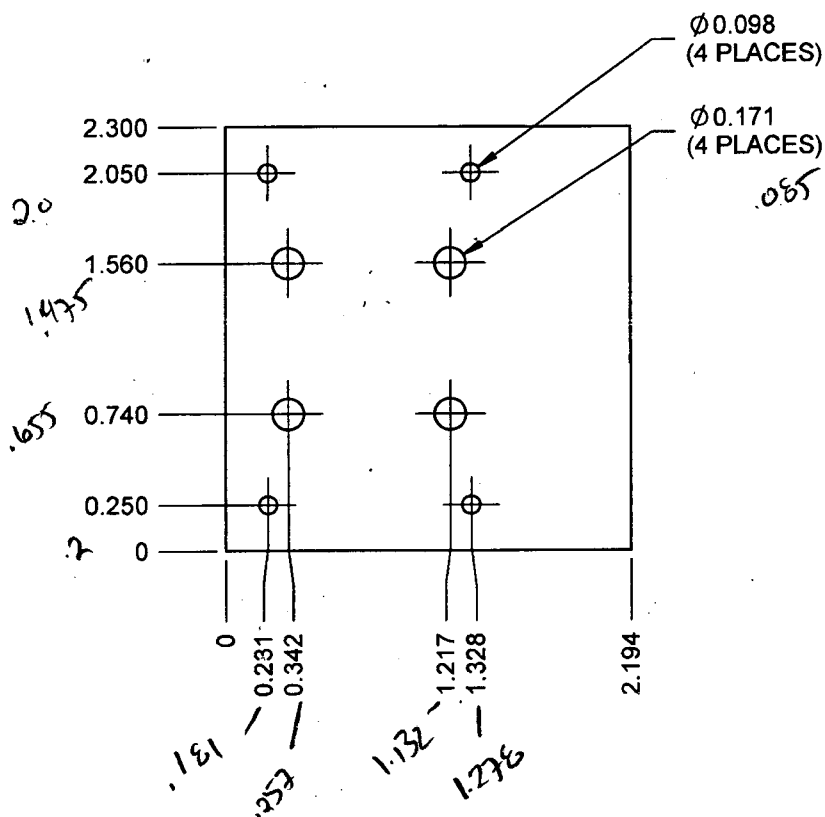
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	BE



cf. 11-2c

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 114310

NO. 44310
PS 10-12-2



D2151 PACKER

NOTES:

- NOTES:
- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
 - 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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